

Work Order ID 71225

Friday, June 24, 2011 11:21:33 AM



Page 1

Item ID: D4035-047

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (Light)

Stop



Start Date: 6/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R Aluminum rod Batch *1114514* 0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9620 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAD 11-07-14

(2)

110



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

S 11/08/03

(2)

11-08-03

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Start Date: 6/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

0.00 *Subs 103*

QC

Memo

Quality Control

2

130

Identify as per dwg & Stock Location: *WAG*

0.00



0.00

Packaging

Memo

Packaging

21.08.3 *2*

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

*CK 11/08/04**11-08-3* *2*

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NOTE: Date & initial all entries

Picklist Print

Friday, June 24, 2011 11:21:39 AM

Page 1

Work Order ID: 71225

Parent Item: D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)



Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4035-11 Bushing		Manufactured	No			100	Each	28.0000	2	4			
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Location	Loc Qty	Loc Code
WA005	28	
59749	16	
63879	12	

M6061T6TS0.750W.06 2		Purchased	No			100	f	216.0060	1.875	3.947368			
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Location	Loc Qty	Loc Code
MAT006	24.11119	
104422	4	
116687	5.11119	
9671	15	
MAT013	191.8948	
117400	191.8948	

Handwritten: PAB 11/07/29

Handwritten: 4
SAD 11-07-04

Handwritten: 39474

W/O:		WORK ORDER CHANGES					
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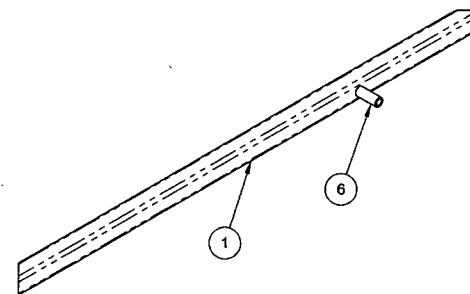
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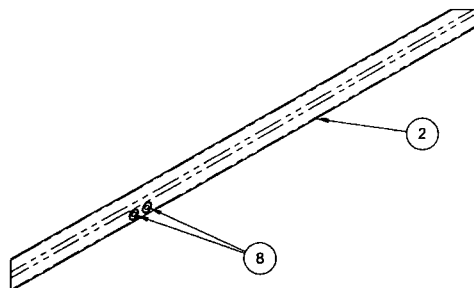
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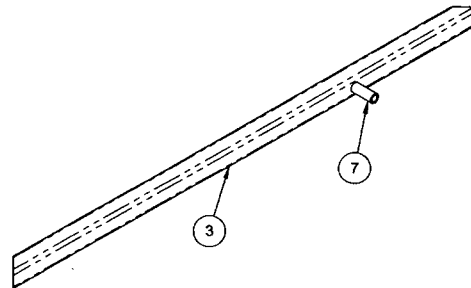
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



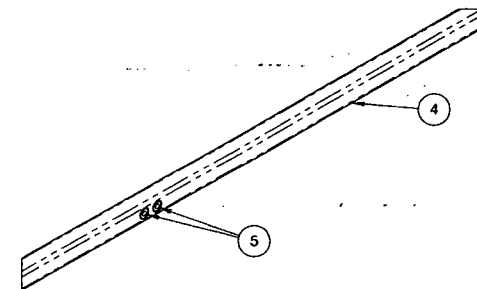
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71225 *pl 11-0624*

RELEASED
2010-03-12
MM

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4035 TITLE BASKET LID RIB ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		REV. A	
DRAWN	JPH			SHEET 1 OF 5	
CHECKED	<i>[Signature]</i>			SCALE	
MFG. APPR.	<i>[Signature]</i>			NTS	
APPROVED	<i>[Signature]</i>				
DE APPR.	<i>[Signature]</i>	DATE		10.03.04	

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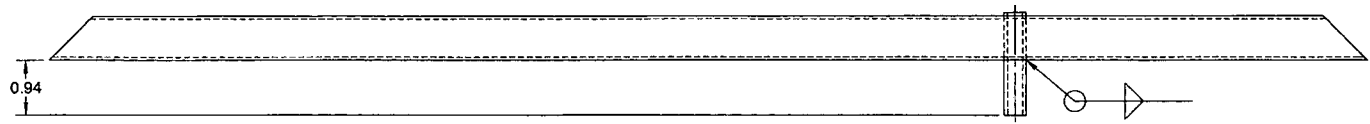
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8 7 6 5 4 3 2 1

D



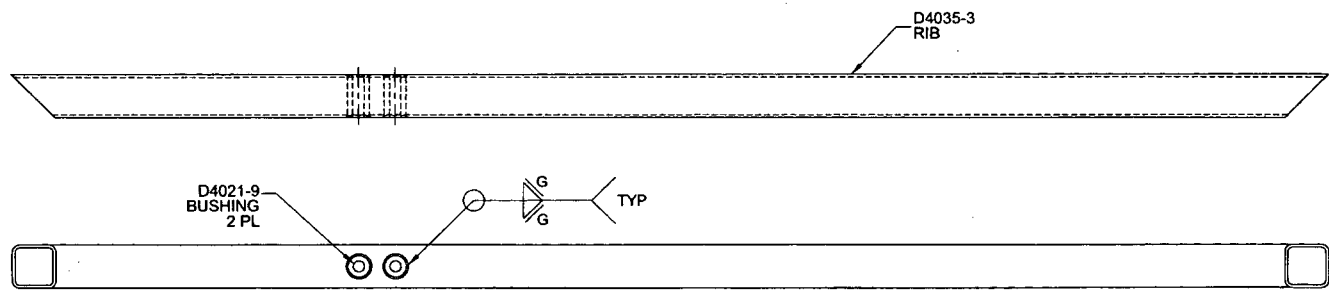
D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY. FWD

C

B



D4021-9
BUSHING
2 PL

G
G

TYP

D4035-043 BASKET LID RIB ASSY. AFT

71225

RELEASED
2010-03-12
WD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

A

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8 7 6 5 4 3 2 1

D

D

D4035-5
RIB

D2953-175
SPACER

0.94

C

C

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

B

B

71225

D4035-11
BUSHING
2 PL

G
G
TYP

A

A

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

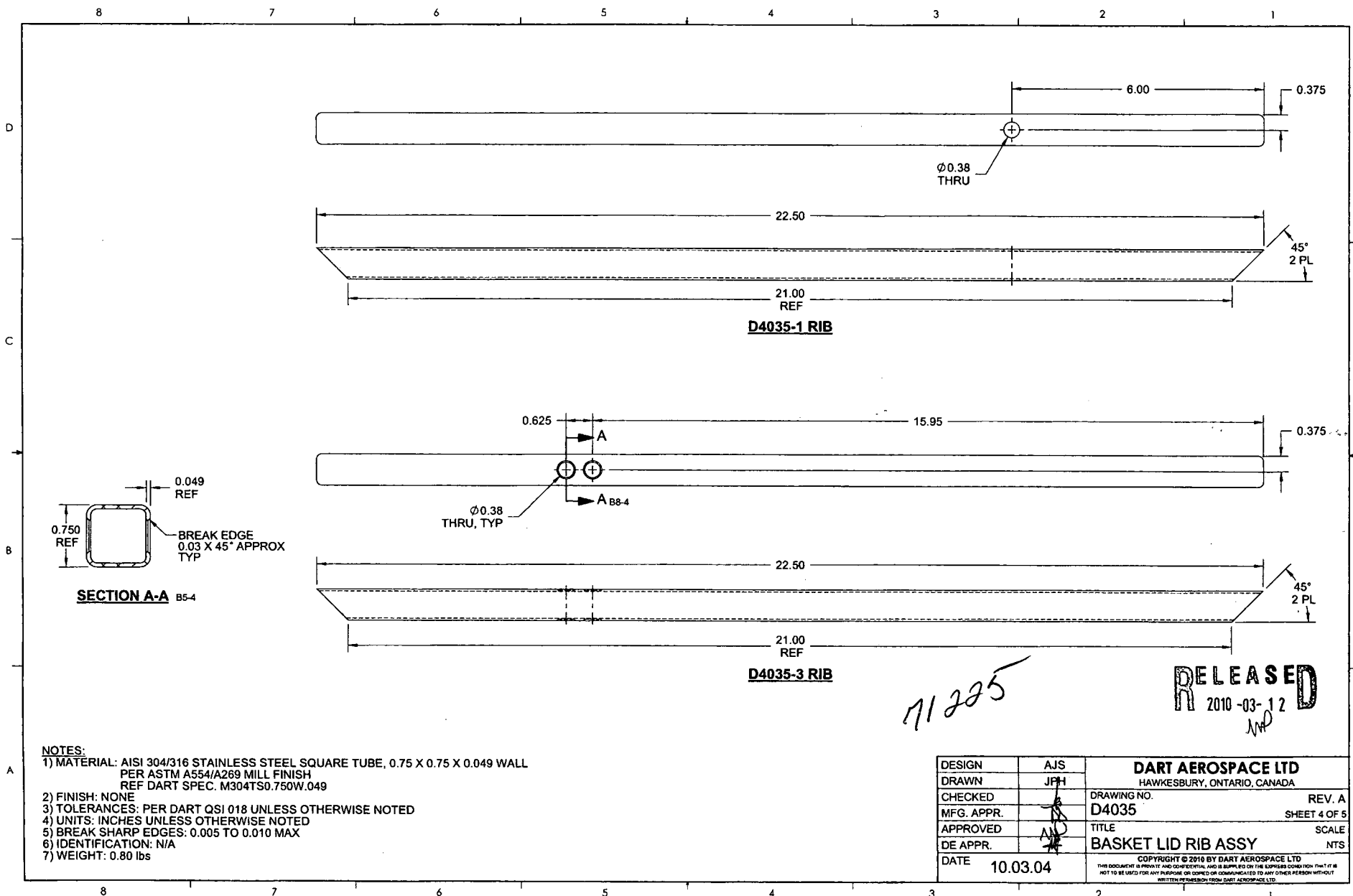
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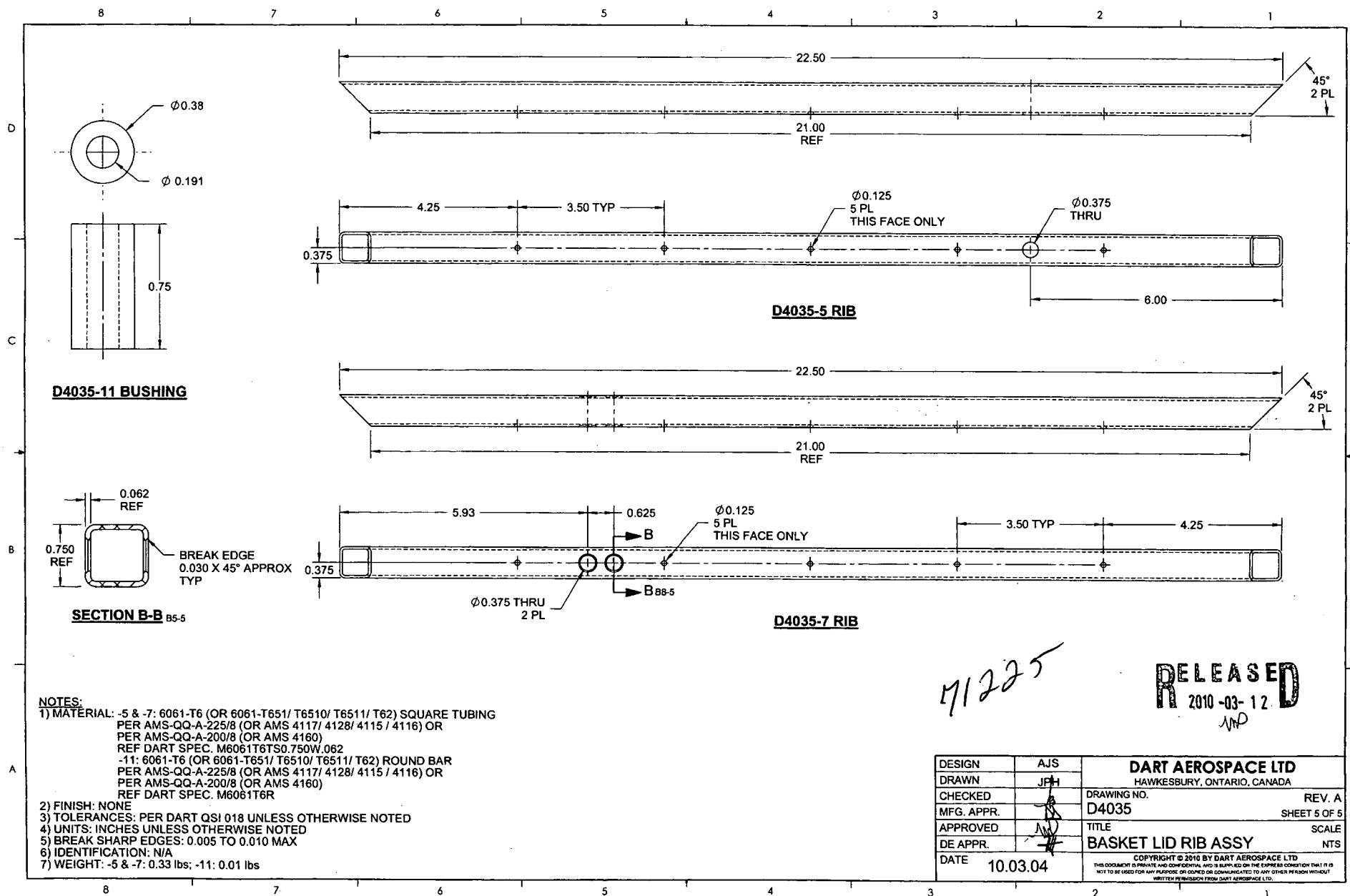
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